Quality Control

Page 1

Monday, June 13, 2011 1:32:22 PM D3537-1 Accept Item ID: Setup Start Revision ID: Stop Wearpad Item Name: Start Qty: 50.00 Start Date: 6/13/2011 Cust Item ID: Required Date: 6/17/2011 Req'd Qty: 50.00 Customer: Reference: Start Run Date://-01-Process Plan: Tooling: Date: Approvals: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Reject Reject Insp. Work Center ID Description Code Qty Qty Number Stamp Run Hours Draw Nbr Revision Nbr D3537 Rev C 0.00 100 FLOW WATER JET B11-6-15 0.00 Waterjet FLOW CNC Waterjet 1-Cut as per Dwg D3537 Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B11-6-15 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 Sulx/15 Memo

Dart A	erospace	Ltd
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W/O:			WO	RK ORDER CHANG	ES		3 4	
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Monday, June 13, 2011 1:32:22 PM



Page 2

Item ID:

D3537-1

Accept



Setup Start

Stop



Revision ID:

Item Name: Start Date:

Wearpad

6/13/2011

Start Qty: 50.00 Reg'd Oty: 50.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Reject

Qty

Accept

Qty

60



QC:

Required Date: 6/17/2011

Date:

SPC (Y/N):

Date:

Stop



Insp.

Stamp

Sequence ID/ Work Center ID

Brake NC Brake NC

NC BRAKE

Operation

Description

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2- Identify as D3537-1

0.00

Set Up/

Run Hours

Tool#

Plan

Code

140

Large Fab

Large Fab

Large Fab

Memo

Memo

Description

Batch A/R

2059B Hardcoat M/18453 - 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any

weld that penetrated through Wearpadif necessary

150

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

52 30 m 8 00.0

11-8-23

Reject

Number

W/O:			WC	ORK ORDER CHANG	ES		1	MENT A	
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Page 3

Item ID:

D3537-1

Accept

Setup Start



Revision ID:

Item Name:

Wearpad

Start Date:

Required Date: 6/17/2011

6/13/2011

Start Qty: 50.00 Req'd Qty: 50.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

QC:

SPC (Y/N): Date:

Date:

Stop

Stop

Sequence ID/ Work Center ID

Quality Control

Memo

Set Up/ Run Hours

Tool ID

Tool # Plan Code Accept

Reject Reject Qty Number

Insp. Stamp

Operation

Description

170

Powdercoat

Powder Coating

Quality Control

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

QC5- Inspect part completeness to step on W/O

Memo START TIME:

OVEN TEMPERATURE:

FINISH TIME:

QC3- Inspect Part Finish

0.00

0.00

Memo

0.00

42 BR 11-8-24

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Page 4

Item ID:

D3537-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Wearpad

Start Date: 6/13/2011

Required Date: 6/17/2011

QC:

Start Qty: 50.00 Reg'd Qty: 50.00

Operation

Description

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

Identify as per dwg & Stock Location:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Start Run

Stop

Sequence ID/

Work Center ID

190

Packaging

Memo

0.00

Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

Packaging

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

NO BR 11-8-04

X(108-27)

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W/O:			WO	RK ORDER CHANG	ES		35. 7		
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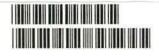
Picklist Print

Monday, June 13, 2011 1:32:28 PM

Work Order ID: 70687

D3537-1 Parent Item:

Parent Item Name: Wearpad



Start Date: 6/13/2011

Required Date: 6/17/2011

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	119.1000	0.106	5.578947			
										1811-	6-15		

304/316 Sheet .063

Loc Qty Loc Code Location MAT020 119.1 4.3 117275 117653 114.8

117653

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DART AEROSPACE LTD	Work Order:	70487
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
X	First Article	Prototype

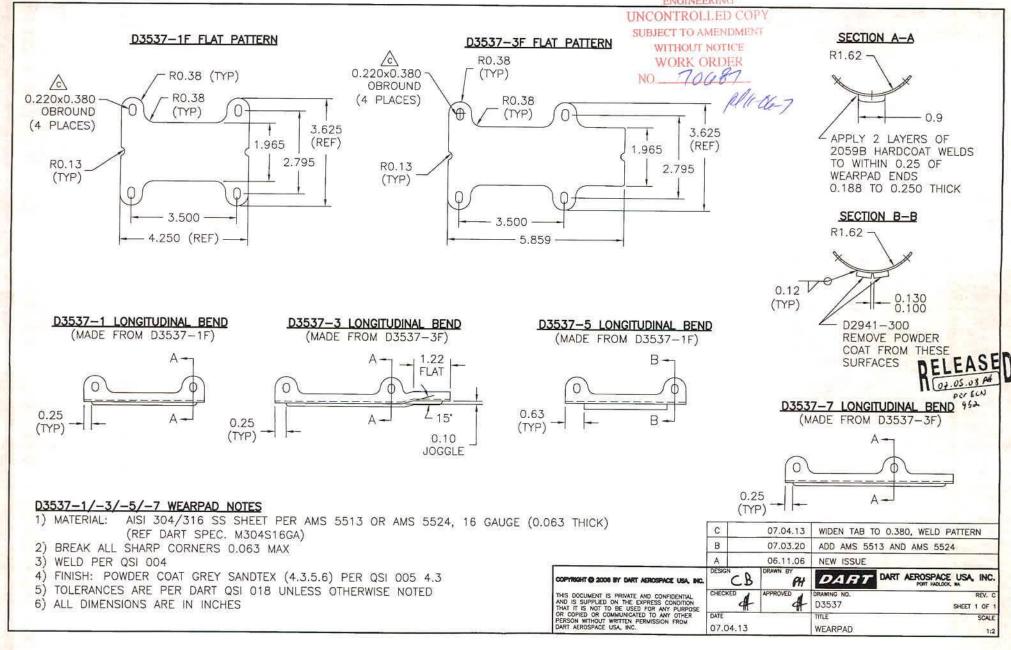
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.248	+		V 1302	
3.500	+/-0.010	3,502	8		ν	
1.965	+/-0.010	1.969	+		ν	
2.795	+/-0.010	2.792	4		V	
3.625	+/-0.010	3626	7		V	
0.220 x 0.380	+/-0.010	990×380	مد		ν	

Measured by:	MS	Audited by:	2	Prototype Approval:	N/A
Date:	11-6-14	Date:	11/06/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM	
В	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	1
С	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM X	all

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